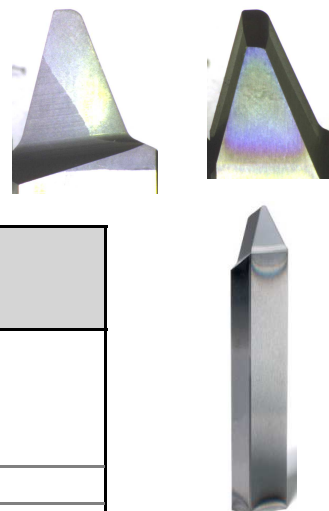
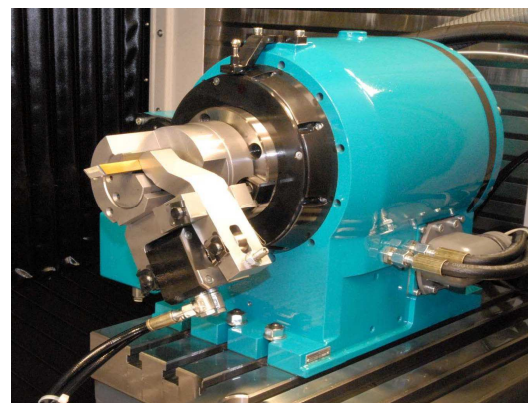


## Gear Blade Oerlikon BxH 10.16 x 12.7

### A12-350

The profiled Gear Blades are ground with DXF based Profileoperation being clamped horizontally in a specially designed automatic clamping device. The 1A1-wheel is used on both sides to grind either the pressure side of the blade or the clearance side of the blade and the cutting face. When inverting the operation on one of the sides, the complete profile can be preground with one side of the profile, preserving the opposite corner for finishing.



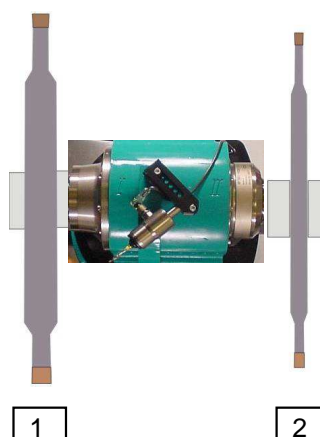
### 1. Cycletime for Resharpener

Workpiece:	RH inner blade Spir; 10.16 x 12.7 x 115 mm					
Material	CARBIDE					
Operations						
Feed [mm/Min]	2000	85	85	90	90	80
Power [kW]		2.1	2.1	0.9	0.9	0.9
Cutting feed [m/s]		19	19	22	22	20
Used wheels						
Grinding time [s]	18	42	42	28	28	32
Total cycle time	3 Min 05					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø250 D181
2	14A1 Ø250 D64



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders :NGC

Control: Fanuc 31i B5

Accessories:

Responsible engineer: 31.10.2014, ADA

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

[www.schneeberger.ch](http://www.schneeberger.ch)

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland  
Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY  
FOR TOOLING